Work Order ID 69850

Friday, May 20, 2011 10:39:35 AM

Item ID: D4038-6 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Block

Start Date: 5/20/2011 **Start Qty:** 2.00 **Cust Item ID:**

Required Date: 6/10/2011 **Req'd Qty:** 2.00 **Customer:**

Reference:

Run Start

Approvals: **Process Plan:** CL **Date:** 11/05/20 **Tooling:** **Date:**

QC: **Date:** **SPC (Y/N):** **Date:** **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr D4038	**Revision Nbr** D U/R								
100		0.00							
Bandsaw	**Memo**	0.00				20			
Jeaspa Bandsaw	CUT BLANK 2.19" LONG								
105		0.00							
HAAS 1	**Memo**	0.00							
HAAS CNC vertical machine #1	Mill as per Dwg and Folio FA883 DWG REV: E FOLIO REV: AA DEBURR					(2)			

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	QC2- Inspect parts off machine FAI/FAIB	0.00	SL 11/06/07			2	ϕ		
QC	**Memo**	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00	B.A 11/06/07			2	ϕ		
QC	**Memo**	0.00							
Quality Control									
130	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish	**Memo**	0.00							
Hand Finishing									

2x ϕ M. L 11/06/08

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

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Run Start

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC3- Inspect Part Finish	0.00				2	0		11/06/08
QC	**Memo**	0.00							
Quality Control									
160	Identify as per dwg & Stock Location G-A W/O 69848	0.00							11/06/09 (2)
Packaging	**Memo**	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							11/6/09 MF 11-06-09
QC	**Memo**	0.00							
Quality Control									

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

Friday, May 20, 2011 10:39:33 AM

Work Order ID: 69850

Parent Item: D4038-6

Parent Item Name: Block

Start Date: 5/20/2011 **Required Date:** 6/10/2011

Start Qty: 2.00 **Required Qty:** 2.00

Comments: Ipp Rev:A New Issue 09-12-14 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.500X02.000		Purchased	No				f	6.8057		0.349474			

6061-T6 Bar 1.50 x 2.00

Location	Loc Qty	Loc Code
MAT010	6.80568	
110167	1	
114608	5.80568	

.349 mk w/ 06/07

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

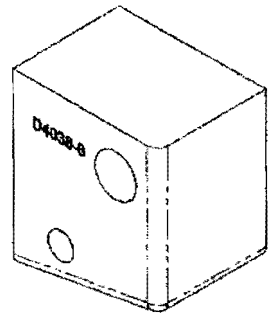
DART AEROSPACE LTD	Work Order:	69850
Description: Block	Part Number:	D4038-6
Inspection Dwg: D4038 Rev: D		Page 1 of 1

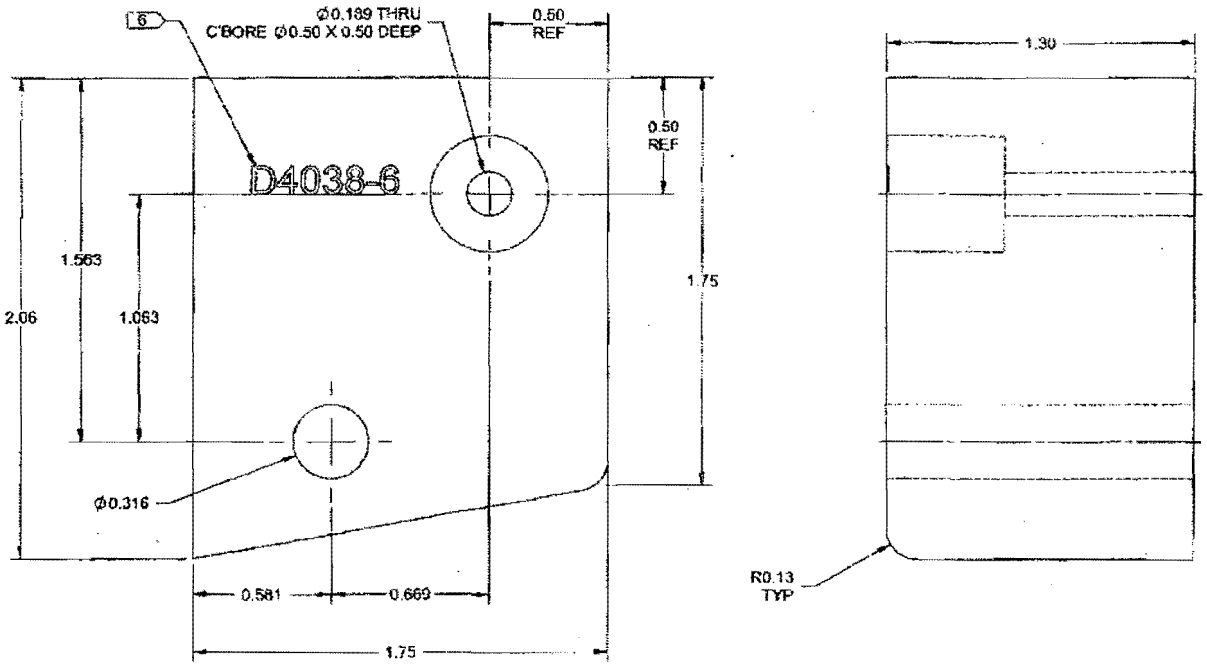
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.30	+/-0.030	1.301	✓		Micrometer	
R0.13	+/-0.030	.125	✓		"	
2.06	+/-0.030	2.062	✓		"	
1.563	+/-0.010	1.563	✓		"	
1.063	+/-0.005	1.063	✓		HG	
Ø0.316	+0.006/-0.001	.316	✓		"	
0.581	+/-0.010	.580	✓		"	
0.669	+/-0.005	.669	✓		HG	
1.75	+/-0.030	1.751	✓		"	
1.75	+/-0.030	1.750	✓		"	
0.50	+/-0.030	.500	✓		"	
0.50	+/-0.030	500	✓		"	
Ø0.189	+0.005/-0.001	.194	✓		"	
Ø0.50 x 0.50 Deep	+/-0.030 x +/-0.030	.500 x .497	✓		"	

Measured by:	JL	Audited by:	B.A	Preliminary Approval:	
Date:	11/06/07	Date:	11/06/07	Date:	

Rev	Date	Change	Revised by	Approved
A	10.06.08	New Issue	KJ	
B	11.04.05	Dwg Rev updated	KJ	





69850

RELEASED
2011-04-21

D4038-6 BLOCK

NOTES:
1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF DART SPEC M6061T6B
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: ENGRAVE P/N IN THIS AREA AS SHOWN TO MAX DEPTH OF 0.010 IN 0.12 HIGH LETTERS WITH MIN RADIUS TOOL OF 0.015
7) WEIGHT: 0.40 lbs

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D4038 — REV. E
MFG. APPR.		SHEET 6 OF 14
APPROVED		TITLE BRACKET — SCALE NTS
DE APPR.		
DATE 11.04.11		

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